

Work Order ID 57423

Page 1

April 6, 2010 3:59:38 PM

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-4-06

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100



Large Fab

0.00

2

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAD 10-04-13

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open
to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: M111679

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: M111679

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

10-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



QC5- Inspect part completeness to step on W/O

0.00

(2) PD 10.04.15

QC

Memo

0.00

Quality Control

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

(2) PD 10.04.15

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: Basket 0.00

0.00

(2) PD 10.04.15

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
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Stop



Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**

140



QC

QC21- Final Inspection - Work Order Release

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

Quality Control

Memo

10/04/14 JJ

B/10-4-14

(2)

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57423



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 06/04/2010

Required Date: 12/04/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3759-1



Manufactured

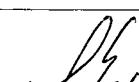
No

100

Each

25.0000

2.0000



PL10-04-15

Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA

Loc Qty

25

Loc Code

M304TS0.750W.065



Purchased

No

100

f

562.8397 2.1720



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA

Loc Qty

562.8397

Loc Code

111148

113956

114137

58

23.5

481.3397

2.1720

2.1720

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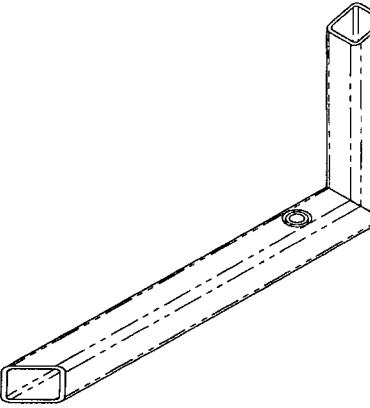
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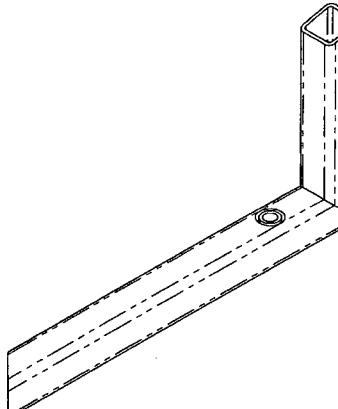
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57423
BD 10-4-08

RELEASED
[Signature]

A	NEW ISSUE	MB	08.10.08
REV.	1	BY	
DESCRIPTION			
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <u>D3838</u> REV. A	
MFG. APPR.		SHEET 1 OF 3	
APPROVED		TITLE <u>RIB ASSY (BASKET LID)</u> SCALE <u>NTS</u>	
DE APPR.		DATE <u>08.10.08</u>	

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8 7 6 5 4 3 2 1

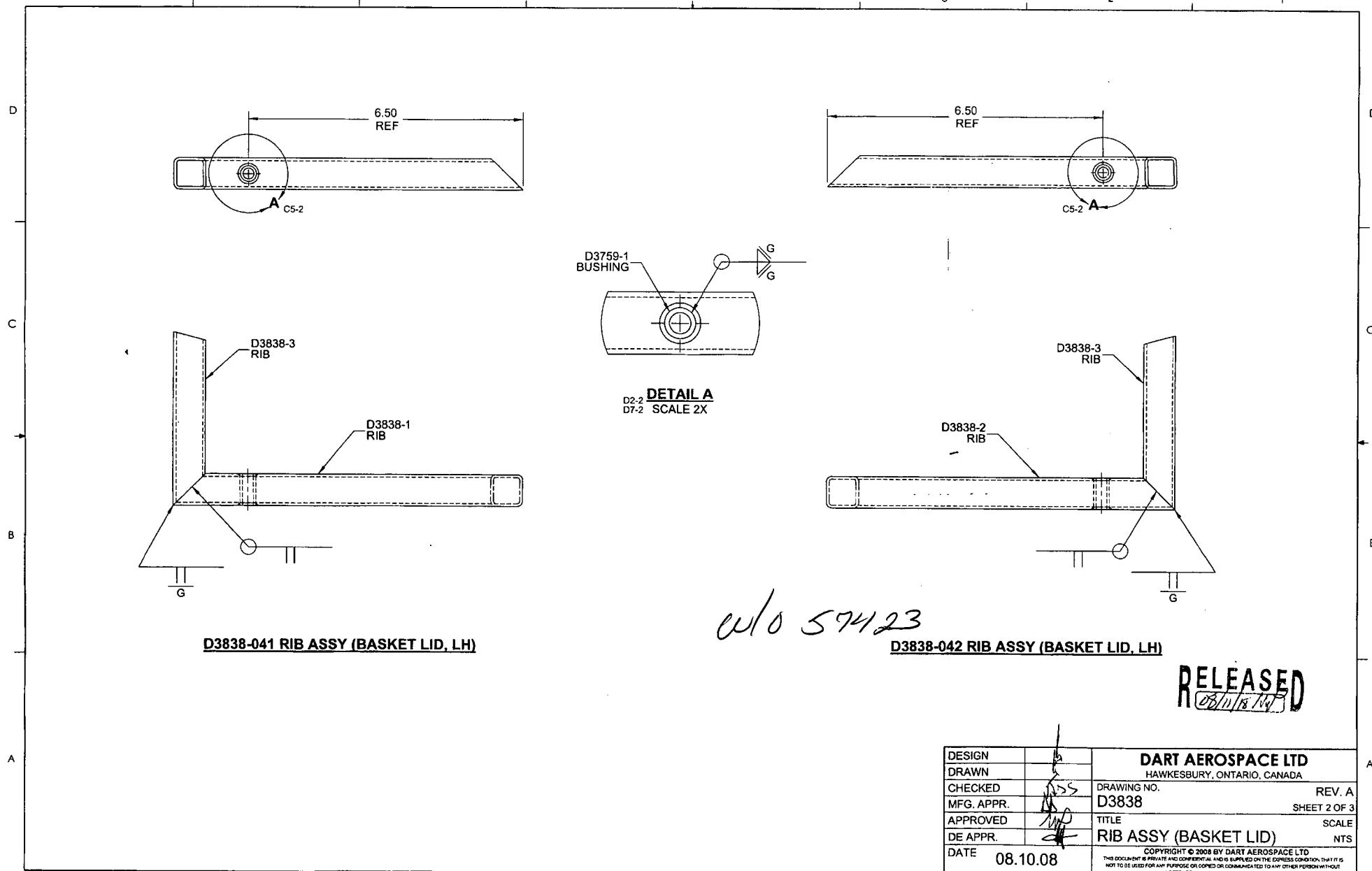
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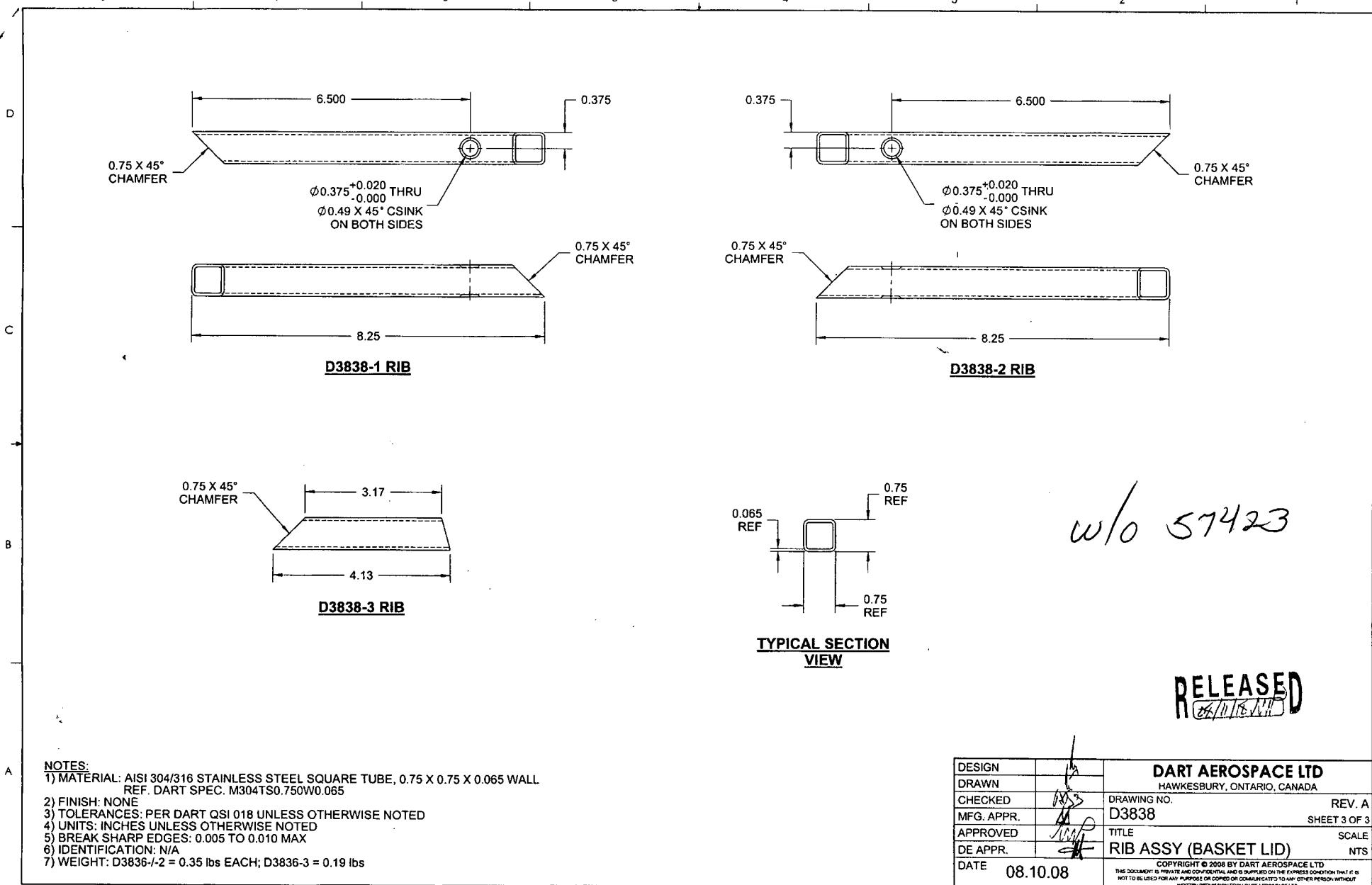
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